

# Work Order ID 43731A

Friday, June 26, 2009 8:42:07 AM



Page 1

Item ID: D3325-041

Accept



Setup Start



Revision ID: B

Stop



Item Name: Basket Lid Assembly

Start Date: 7/15/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 7/15/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3325

Rev B

100

0.00



Large Fab

Large Fab

Large Fab

Memo

0.00

1-Cut tubes as per Dwg D3325-1 Qty Part Number Description  
Batch 2D3325-1 End Tube m109385 3D3325-3 Interior  
Tube m109385 2D3325-5 Full Length Tube m109385 Identify  
parts appropriately ☐ 2-Remove all markings from

SAO 09-07-02

PD 09-07-14

PD ->

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Quality Control

Memo

0.00

PD 09-07-15

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

0.00

27 809/07/15

QC

# Dart Aerospace Ltd

W/O: 43731A		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09-07-17	130	Add pressure wash <del>sequence</del> to clean the part, prior to powder coating.  perm change	MA	09/07/28		09-07-17	09-07-17	
09-07-17	100	Sequence comments are incomplete. Please complete & place in order of operation, step by step.  EST # perm change	MA	09/07/28		09-07-17	09-07-17	

Part No: D3325-041 PAR #: N/A Fault Category: Large FAS NCR: Yes No DQA: MA Date: 09-08-05  
Rework / Re-work QA: N/C Closed: MA Date: 09-08-20

NCR: 43731A		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/7/14	#100	welder welded D3367-1 Brackets Prior to welding the mesh. in so the Basket "Twisted" slightly causing the	09/07/14 #20	Remove mesh from D3367-1's QTY (2). Buff Area clean Re weld as per QSI 004 QTY (2) B D3367-1	09/07/14	09/07/15	09/07/14 #20	09/07/14
		D3367-1's not to align with the Base. <del>Re-welder don't follow the correct process</del>	09/07/14 #20	<del>B#43228</del>	09-07-14	09/07/15	09/07/14 #20	09/07/14
		QC: Basket welded <del>cracked</del> cracked (warped) A minor process issue	09/07/14 #20				09/07/14 #20	09/07/14

NOTE: Date & initial all entries



0360.721.041

Dart Aerospace Ltd.

Date: Wednesday, 26/11/2008 9:14:40 AM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET LID ASSEMBLY
Job Number : 43731A	
Estimate Number : 10853	
P.O. Number :	Part Number : D3325041
This Issue : 26/11/2008 S.O. No. :	Drawing Number : D3325 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 41774A	Material :
Written By :	Due Date : 03/12/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 08.11.26</u>	
Comment : Est Rev:A 05.02.09 New Issue KJ/JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 ✓	D33281	Basket Hinge
-------	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description Batch
2 D3328-1	Hinge Plate

B33871

Pl 09.07.14

2.0 ✓	D33491	Spacer Bushing
-------	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description Batch
2 D3349-1	Spacer Bushing

B34209

Pl 09.07.14

3.0 ✓	D33521	Label Plate
-------	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number	Description Batch
1 <del>X</del> D3352-1	Label Plate

B41925

Pl 09.07.14

4.0 ✓	D33671	Mounting Bracket
-------	--------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number	Description
2 D3367-1	Mounting Bracket

Batch B43228

Pl 09.07.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

Friday, June 26, 2009 8:42:07 AM

Work Order ID: 43731A



Parent Item: D3325-041RevB



Parent Item Name: Basket Lid Assembly

Start Date: 7/15/2009

Required Date: 7/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3328-1RevB 		Manufactured	No			100 ✓	Each	0.0000	2.0000			
Basket Hinge									333871			
✓ D3349-1RevA 		Manufactured	No			100 ✓	Each	0.0000	2.0000			
Spacer Bushing									334205			
✓ D3352-1RevA 		Manufactured	No			100 ✓	Each	0.0000	1.0000			
Label Plate									341925			
✓ D3367-1RevA 		Manufactured	No			100 ✓	Each	0.0000	2.0000			
Mounting Bracket									343228			
✓ M4130NTS0.500W.035 		Purchased	No			100 ✓	f	0.0000	21.6227			
4130 Square tube .500 x .500 x .035w									71109385 SAM			

0907-102

Date: Wednesday, 26/11/2008 9:14:40 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 43731A

Part Number: D3325041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

M4130NTS0500W035

4130 Square tube .500 x .500 x .035w



Comment: Qty.: 21.5687 f(s)/Unit Total: 21.5687 f(s)  
Material: 4130 Cond. N Square tube per MIL-T-6736,  
1/2" x 0.035" wall  
M4130N-TS0.500W.035)

M109385

SAD 09-07-02 (2)

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
1-Cut tubes as per Dwg D3325

Qty	Part Number	Description	Batch
2	D3325-1	EndTube	<u>M109385</u>
3	D3325-3	Interior Tube	<u>M109385</u>
2	D3325-5	Full Lengh Tube	<u>M109385</u>

Identify parts appropriately

→ SAD 09-07-02 (2)

2-Remove all markings from material

3-Drill and Weld as per Dwg D3325 & QSI 004  
A/R4130 Steel Rod M100075

4-Deburr as required

PLO 09-07-14

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-07-15

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 09/07/15 (20)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Wednesday, 26/11/2008 9:14:40 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 43731A

Part Number: D3325041

Job Number:



Seq. #:

Machine Or Operation:

Description :

FINISH TIME: \_\_\_\_\_

\*\*\*\*\* 2nd coat if necessary\*\*\*\*\*

2ND COAT:

START TIME: \_\_\_\_\_

OVEN TEMPERATURE: \_\_\_\_\_

FINISH TIME: \_\_\_\_\_



10.0



QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_



12.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



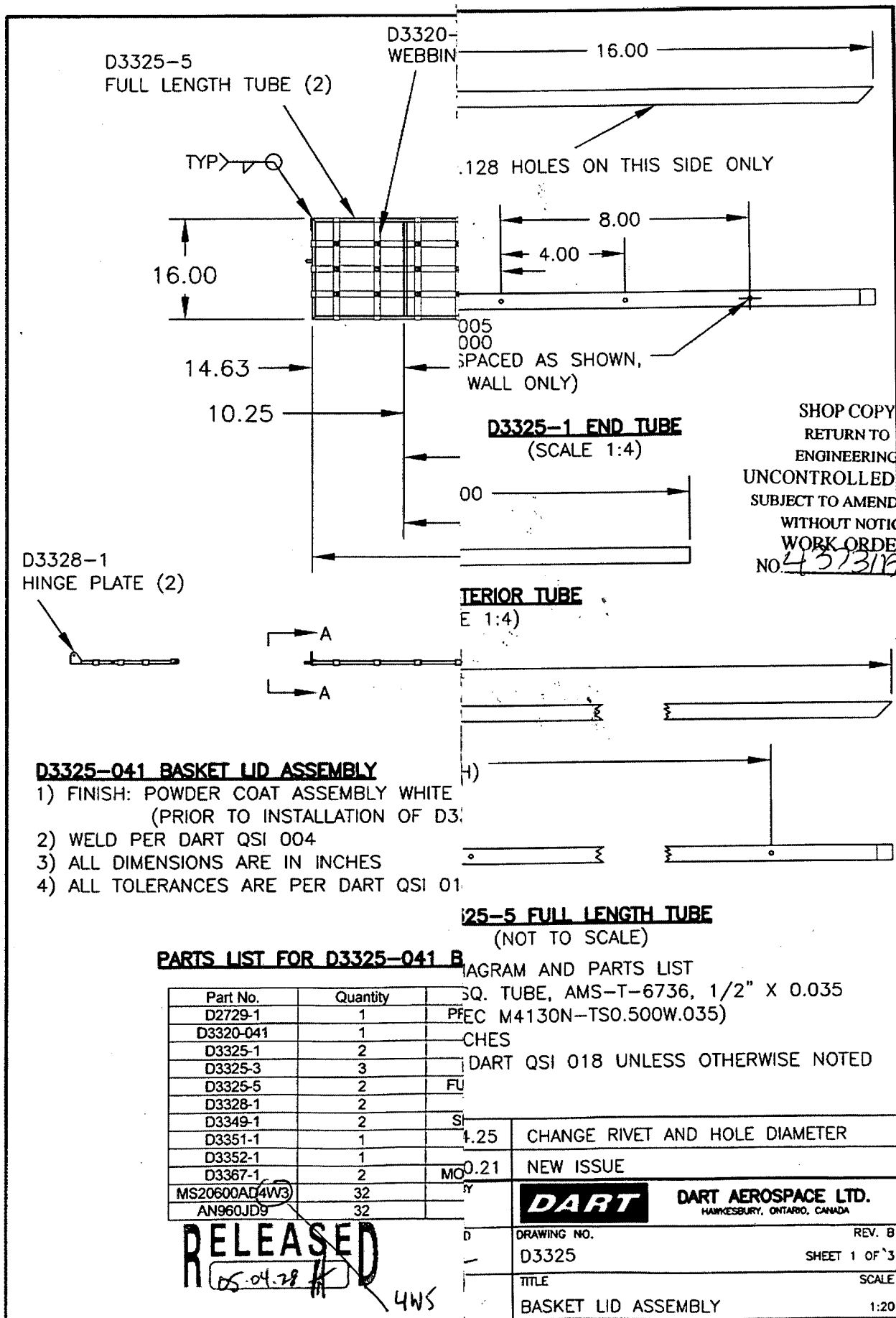
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

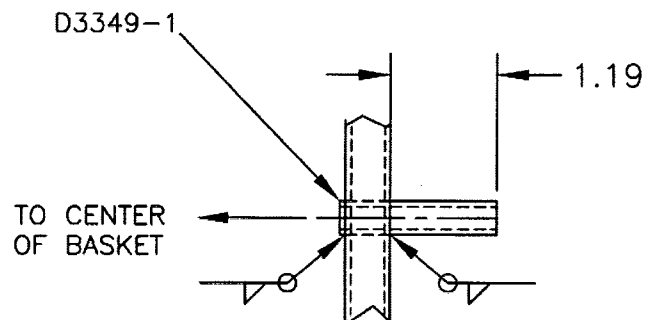
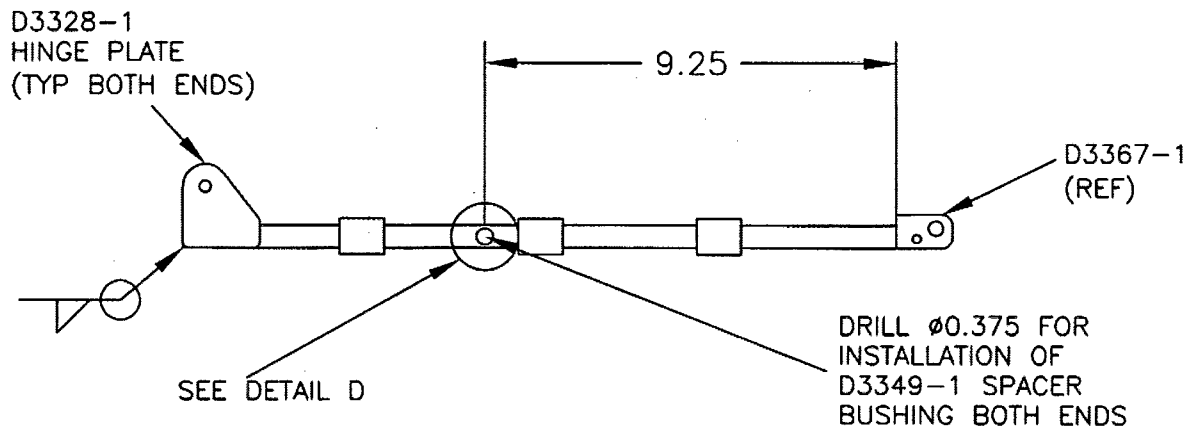
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WORK ORDER  
NO. 437318

**DART**

DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3325	REV. B SHEET 2 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4



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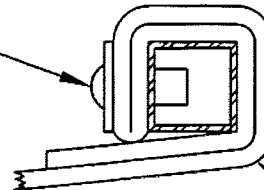
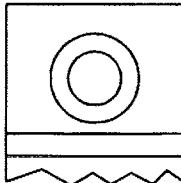
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**DART**

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CHECKED PH	APPROVED PH	DRAWING NO. D3325	REV. B SHEET 3 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4

4WS PH 08.11.26

MS20600AD4W3 RIVET (1)  
AN960JD9 WASHER (1)

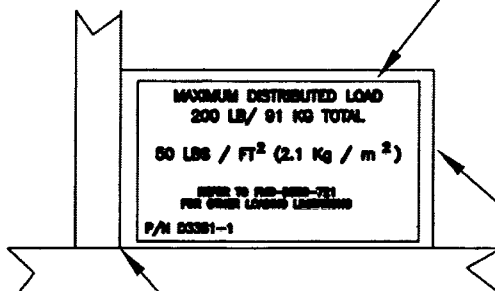


DETAIL B  
TYP. ATTACHMENT OF WEBBING TO LID  
FRAME  
(SCALE 1:1)

D3320-041 WEBBING

**RELEASED**  
05.04.28 PH

ATTACH D3351-1 PLACARD  
ON TOPSIDE OF D3352-1



D3352-1

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WORK ORDER  
NO. 437318

IDENTIFY WITH DART P/N  
D350-721-041 USING  
D2729-1 PRODUCT ID LABEL  
INSTALLED ON UNDERSIDE OF  
D3352-1

DETAIL C  
LABEL PLATE ATTACHMENT  
(SCALE 1:2)

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